

Work Order ID 159671

Monday, April 17, 2017 1:06:05 PM

159671

U/R N/A
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File 4/18
concession only Efforts 24842-3/-4 + 24842-01

Item ID: D4842-1 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Lower Cutter Deflector
Start Date: 4/18/2017 Start Qty: 4.00 *4* Cust Item ID:
Required Date: 4/24/2017 Req'd Qty: 4.00 *4* Customer:
Reference: SCHEDULED/U

Approvals: Process Plan: [Signature] Date: APR 17 2017 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4842	B								

100 0.00
100
Bandsaw Memo 0.00
Jeaspa Bandsaw Cut Blank at 19.500"
DAS 20 17-04-19
9-89

*** ONE BLANK MAKES TWO PARTS ***

110 2.12
110
HAAS 1 Memo 0.68
HAAS CNC vertical machine #1 1-Machine per folio FB222
DWG REV: B
FOLIO REV: AA
DAS 20 17-04-21
9-89

2- deburr and break all sharp edges

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				4	Ø		DAS 20 9-89 1704-2
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				4	Ø		DAS 08 9-89
140 *140* Outsource4 Outsource process - Anodize	Outsource process-Anodize per QSI017 4.1.10.1 Memo Issue P/O to ATG : 36166 1- Black Anodize as per Dwg D4842 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Comformity is required	0.00 0.00				4		MAY 02 2017	DAS 13 9-89

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Revision ID:					Stop	*NS2*
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Required Date:	4/24/2017	Req'd Qty:	4.00	*4*	Customer:	
Reference:	SCHEDULED/U					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150									
Packaging	Memo	0.00							
Packaging									
155	QC5- Inspect part completeness to step on W/O	0.00							
155									
QC	Memo	0.00							
Quality Control	3.6 mils thickness primer								
180	Identify as per dwg & Stock Location: <u>ck035</u>	0.00							
180									
Packaging	Memo	0.00							
Packaging									

4K 8017-5-30

4

DAS 38 9-89

MAY 30 2017

4

DAS 6 9-89

MAY 30 2017

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

17/5/31 AJ

DAS
21
9-89

MAY 3 2017

Picklist Print

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Work Order ID: 159671

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Parent Item: D4842-1

D4842-1

Parent Item Name: Lower Cutter Deflector

Start Date: 4/18/2017

Required Date: 4/24/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 13.04.26 NEW ISSUE DD VERF:JLM IPP
REV:B PROCESS CHANGE 13/10/29 JFS VERIFY BY: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M7075T6B5.000X0.375

Purchased

No

100

f

18.7810

0.813

3.423158

M7075T6B5.000X0.375

3.208'

DAS

20

9-89

17-04-19

7075-T6 BAR 5.000" X 0.375"

Location

Loc Qty

Loc Code

MAT005

18.781

m134829

3.291

m135320

1

m136103

0.875

m136303

0.917

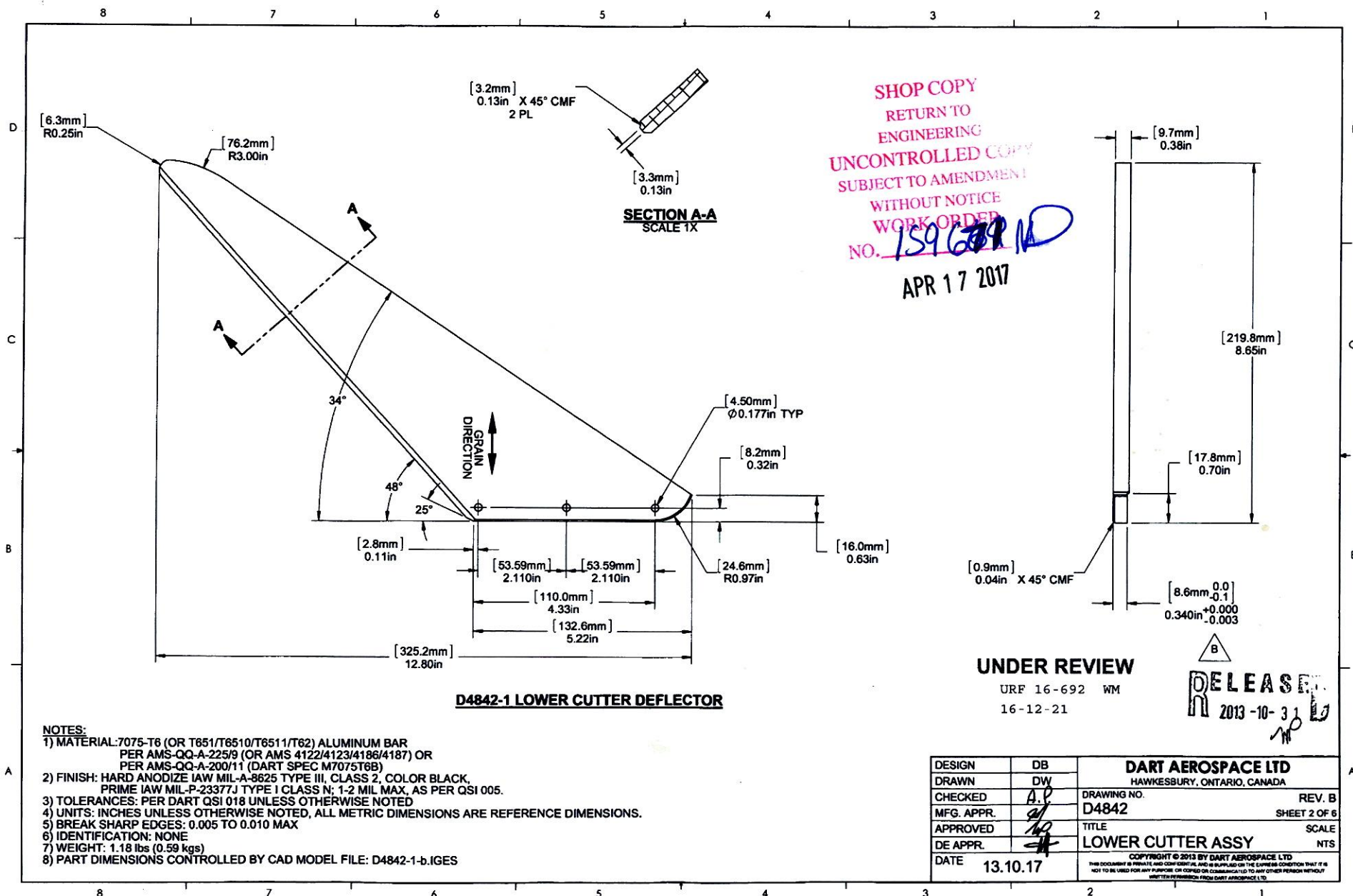
m136965

0.698

m137090

12

3.208'



DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO36166

Purchase Order Date 5/2/2017

PO Print Date 5/24/2017

Page Number 1 of 11

Order From :

VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
EC MAY 25 2017

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	159671	D4842-1 LOWER CUTTER REV. B	6/16/2017 Yes 6/16/2017		4.00	\$12.05	\$48.20
FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-PRF-23377 TYPE I CLASS N							
Line Total:							\$48.20
2	159676	D4842-3 LOWER CUTTER REV. B	5/29/2017 Yes 5/29/2017		6.00	\$10.25	\$61.50
FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-PRF-23377 TYPE I CLASS N							
Line Total:							\$61.50
3	159677	D4842-4 LOWER CUTTER REV. B	5/29/2017 Yes 5/29/2017		6.00	\$10.25	\$61.50
FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-PRF-23377 TYPE I CLASS N							

PO Instructions: PRIMER IS SUPPLIED BY DART

Note:

5/24/2017

SP17-5-26



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913323

Date: 30-May-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
4 ea	Part: D4842-1 Lower Cutter Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (.1 - 2 mils) per drawing. Job: 21053	Rev: B	PO: PO36166 Line: 1
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>30/5/17</u> Certified Signature: <u>[Signature]</u> Receiver Signature: <u>[Signature]</u> A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. 8917-5-30			
Made in Canada.			